

Work Order ID 130579

Monday, March 16, 2015 3:20:00 PM

130579

Page 1

Item ID: D3436-044 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step RH
 Start Date: 3/16/2015 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 3/16/2015 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: 1503-16 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3436	Rev A								

100

0.00

100

Large Fab

Large Fab

Large Fab

Memo

0.00

Weld bushings D3436-5 and clamp D3436-1 using welding Jig DT8772 and

Dwg D3436Dwg Rev: 2

Qty Part Number Description Batch

A/RN/A 4130 Welding Rod 127925

Weld right step D3436-4 using welding Jig DT8773 and Dwg D3436Dwg

Rev: 4

Qty Part Number Description Batch

A/RN/A 4130 Welding Rod 127925

Weld cap D3436-7 as per Dwg D3436Dwg Rev: A

Qty Part Number Description Batch

A/RN/A 4130 Welding Rod 127925

2 EL 15-3-18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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Doc/Data									
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Revision ID: Stop ***NS2***
Item Name: Step RH
Start Date: 3/16/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 3/16/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
140	<i>m 129808</i>					<i>2</i>	<i>0</i>	<i>15-3-24</i>	<i>98 98 98</i>
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>11:00</i>								
	OVEN TEMPERATURE: <i>400°</i>								
	FINISH TIME: <i>11:30</i>								
145	Wing Walk as per dwg QSI005 4.4 Batch <i>113158</i>	0.00							
145									
HandFinish	Memo	0.00							
Hand Finishing	Wing Walk B <i>113158</i>								
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									
					DAS 30 9-89	<i>2</i>			<i>15/03/21</i>

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Handling/Pre									
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Offset/Setup									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Item ID: D3436-044 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step RH
Start Date: 3/16/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 3/16/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21 - Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

MLJ 15-0410

PS-4-9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Monday, March 16, 2015 3:20:03 PM

Page 1

Work Order ID: 130579

130579

Parent Item: D3436-044

D3436-044

Parent Item Name: Step RH

Start Date: 3/16/2015

Required Date: 3/16/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A 05.05.11New IssueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3436-5		Manufactured	No			100	Each	9.0000	4	16			
D3436-5													
Bushing													

Location Loc Qty Loc Code

WA002 9
120944 9

D3436-7		Manufactured	No			100	Each	0.0000	1	4			
D3436-7													
Cap													

130593x2

Location Loc Qty Loc Code

GA 3
105682 3

D3436-9		Manufactured	No			100	Each	3.0000	2	84			
D3436-9													
Pad													

DAS 28 MAR 31 2015 9:00

Location Loc Qty Loc Code

GA 3
105682 3

D3436-4		Manufactured	No			100	Each	5.0000	1	4			
D3436-4													
Right Step													

Location Loc Qty Loc Code

WA001 5
126857 5

D3436-1		Manufactured	No			155	Each	19.0000	1	4			
D3436-1													
Clamp													

Location Loc Qty Loc Code

WA002 19
96663 19

DQA: _____ Date: _____



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